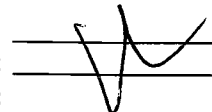


Date: Thursday, 08/01/2009 9:01:48 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-559-011 TO D120-638-011
Job Number	: 44494		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D120638011
This Issue	: 08/01/2009 S.O. No. :	Drawing Number	: DISASSEMBLE
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 08/01/2009 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D206-559-011 B37535 ✓

DISASSEMBLE KIT TO MAKE A D120-638-011

D2435 BEARPAW IS SAME FOR BOTH KITS B37535

REMOVE FROM D206-559-011

AND RETURN TO STOCK (ADJUST ACCPAC) 8 X AN4-17A B M1056538 X A N960JD416 B M1062772 X QS200M44S B M107035

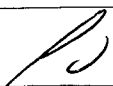
2.0

D206559011

Bearpaw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bearpaw B 37535

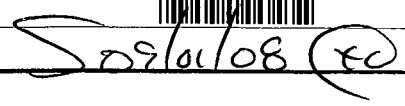
3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

CHC7002

Comment: INSPECT 100% KITS FOR COMPLETENESS



Date: Thursday, 08/01/2009 9:01:48 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-559-011 TO D120-638-011

Job Number: 44494

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP D120-638-011
CHG 002

REVA *8/1/07* (1)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/1/08 (1)

Job Completion



40901.08

Date: Thursday, 08/01/2009 9:01:13 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37535	Customer	: Dart Helicopters Services
Estimate Number	: 12664	DWG Name	: BEARPAW KIT (19"X16")
Purchase Order #	:	Part Number	: D206559011
Complete Date	: 07/03/2008 1:24:50	DWG Number	: D2435 UNDER REVIEW
		Rev.	: E1

DUE DATE	ORDERED	DELIVERED
03/03/2008	6	6

2.0 MUHMWB10-UHMW 1" Black INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
27/02/2008	LAMA01: Lamarche, Mathieu	MUHMWB10	27.295		\$522.24		Lot # 105862 Qty. 27
Subtotal:		QTD:	0	CTD:	27	\$522.24	

3.0 HAAS1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
03/03/2008	AUCL01: Auclair, Guillaume	Setup	11.000	1.10	\$19.94	1.10	31.51
03/03/2008	AUCL01: Auclair, Guillaume	Run	0.000	5.57	\$100.98	5.57	159.55
04/03/2008	LARO02: Larocque, Julien	Run	12.000	9.44	\$171.15	9.44	270.42
04/03/2008	LARO02: Larocque, Julien	Completed	23.000	0.00	\$0.00	0.00	0.00
Subtotal:		QTD:	23	CTD:	23	16.11	\$753.55

7.0 D2182B-Rubber Cushion INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	D2182B	10.000		\$10.95		Lot # 35769 Qty. 10
Subtotal:		QTD:	0	CTD:	10	\$10.95	

8.0 D2274-Radius Block INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	D2274	48.000		\$53.51		Lot # 36624 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$53.51	

9.0 D2438-Clamp INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	D2438	24.000		\$151.93		Lot # 36027 Qty. 24
Subtotal:		QTD:	0	CTD:	24	\$151.93	

10.0 D2529-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	D2529	48.000		\$1.74		Lot # 37210 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$1.74	

11.0 AN415A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	AN415A	48.000		\$9.51		Lot # 106375 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$9.51	

12.0 AN417A-Bolt INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/03/2008	DESJ02: Desjardins, Line	AN417A	48.000		\$14.41		Lot # 105653 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$14.41	

REFERENCE ONLY

Date: Thursday, 08/01/2009 9:01:14 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 37535	Customer	: Dart Helicopters Services
Estimate Number	: 12664	DWG Name	: BEARPAW KIT (19"X16")
Purchase Order #	:	Part Number	: D206559011
Complete Date	: 07/03/2008 1:24:50	DWG Number	: D2435 UNDER REVIEW
		Rev.	: E1

13.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
07/03/2008	DESJ02: Desjardins, Line <i>removed</i>	AN960JD416	96.000	\$2.81	Lot # 106277 Qty. 96
Subtotal:			QTD: 0 CTD: 96	\$2.81	

14.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
07/03/2008	DESJ02: Desjardins, Line	MS21042L4	48.000	\$7.86	Lot # 105938 Qty. 48
Subtotal:			QTD: 0 CTD: 48	\$7.86	

15.0 QS200M44S-Clamp INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
07/03/2008	DESJ02: Desjardins, Line <i>removed</i>	QS200M44S	12.000	\$59.88	Lot # 107035 Qty. 12
Subtotal:			QTD: 0 CTD: 12	\$59.88	

		TIME	COST	
	Machine Time:	16.11	\$461.48	
	Labor:	16.11	\$292.07	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$834.84	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$1588.39	

COST PER UNIT: \$264.73

Date: Thursday, 08/01/2009 8:48:27 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number : D206559011

Revision : E1

Drawing Name : BEARPAW KIT (19"X16")

Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	43.00	0.00
2	MFG ENGINEERING	MFG ENGINEERING	0.00	Hours	0.00	0.00
3	MUHMWB10		3.40	sf	0.00	0.00
4	WATER JET	FLOW WATER JET	0.00	Hours	112.00	0.00
5	HAAS1	HAAS CNC VERTICAL MACHINING #1	0.00	Hours	98.00	0.00
6	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	0.00	Hours	45.00	0.00
7	QC8	SECOND CHECK	0.00	Hours	43.00	0.00
8	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
9	D2182B	Pick: Packing Kit	1.66	f	0.56	0.93
10	D2274	Pick: Packing Kit	8.00	Each	0.54	4.32
11	D2438	Pick: Packing Kit	4.00	Each	3.60	14.40
12	D2529	Pick: Packing Kit	8.00	Each	0.02	0.16
13	AN415A	Pick: Packing Kit	8.00	Each	0.00	0.00
14	AN417A	Bolt <i>remove</i>	8.00	Each	0.21	1.75
15	AN960JD416	Pick: Packing Kit <i>remove &</i>	16.00	Each	0.00	0.00
16	MS21042L4	Pick: Packing Kit	8.00	Each	0.00	0.00
17	QS200M44S	Pick: Packing Kit <i>remove</i>	2.00	Each	0.00	0.00
18	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	43.00	0.00
19	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
20	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						21.57

D2435
 D20-638 - CHS 002

REFERENCE ONLY

~~34220~~
 34535

Date: Thursday, 08/01/2009 8:48:19 AM

User: Linda Lacelle

Bill of Manufacturing

Part Number : D120638011		Revision : E1				
Drawing Name : BEARPAW KIT (19"X16")		Default Qty. : 1				
Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	43.00	0.00
2	MFG ENGINEERING	MFG ENGINEERING	0.00	Hours	0.00	0.00
3	MUHMWB10	blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000)	3.36	sf	0.00	0.00
4	WATER JET	FLOW WATER JET	0.00	Hours	112.00	0.00
5	HAAS1	HAAS CNC VERTICAL MACHINING #1	0.00	Hours	98.00	0.00
6	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	0.00	Hours	45.00	0.00
7	QC8	SECOND CHECK	0.00	Hours	43.00	0.00
8	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
9	D2182B	Pick: Packing Kit	1.66	f	0.56	0.93
10	D2274	Pick: Packing Kit	8.00	Each	0.54	4.32
11	D2438	Pick: Packing Kit	4.00	Each	3.60	14.40
12	D2529	Pick: Packing Kit	8.00	Each	0.02	0.16
13	AN415A	Pick: Packing Kit	8.00	Each	0.00	0.00
14	AN960JD416	Pick: Packing Kit	8.00	Each	0.00	0.00
15	MS21042L4	Pick: Packing Kit	8.00	Each	0.00	0.00
16	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	43.00	0.00
17	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	37.00	0.00
18	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						19.81

REFERENCE ONLY